

Work Order ID 53308

October 29, 2009 3:18:54 PM



Page 1

Item ID: PB67-43001-59

Accept



Setup Start



Revision ID: B1

Stop



Item Name: PB67-43001-59

Start Date: 10/30/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 11/13/2009 Req'd Qty: 1.00

Customer:

Reference:

Approvals: Process Plan: mf

Date: 09-10-29 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
B67-43001	Rev B1								
100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1- to make -105 take M6061T6 tube and fabricate to fit contour of cut□2- Weld - 105 to -113 as per dwg and grind weld flush□3- weld 119, -117 and -115 to - 113 as per dwg PB67-43001□4- pick two -271 and weld one on each side of tubing but only one need to b								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
QC	Memo	0.00							
Quality Control									
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

88 10-01-08

PD 10.01.08 ①

2 81061/08

⑩

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

Handwritten: 2/AS

0.00

Hand Finishing

140

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

0.00



Powdercoat

Memo

START TIME:

Handwritten: 8:20

OVEN TEMPERATURE:

Handwritten: BL 10-01-11

Handwritten: 0

320° FINISH TIME:

Handwritten: 8:50

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

Handwritten: 10-01-11

Handwritten: (X)

Handwritten: 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Small Fab	Small Fab	0.00				(1)			
Small Fab	Memo	0.00							
Small Fab	1- take -267 and transfer drill holes in -113 as per dwg PB67-43001□2- deburr and rivet -267 to -113 as per dwg□3- assemble rest of parts as per dwg PB67-43001								
					SAP 10-01-12				Ph * →
170  QC	QC5- Inspect part completeness to step on W/O	0.00				(40)			
Quality Control	Memo	0.00							
180  Packaging	Identify as per dwg & Stock Location: 437A	0.00							
Packaging	Memo	0.00							
						10-1-12		(125)	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 11/13/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/13

ME
10-1-12 PH →

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 53308

Parent Item: PB67-43001-59RevB1

Parent Item Name: PB67-43001-59

Start Date: 10/30/2009


Required Date: 11/13/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

30345T21  LANYARD		Purchased	No			160	Each	41.0000	2.0000			
--	--	-----------	----	--	--	-----	------	---------	--------	--	--	--

sp 09.12.15

Warehouse Loc Qty Loc Code

Location


Main Warehouse

ST

41

17828

41

BSP43  RIVET		Purchased	No			160	Each	114.0000	6.0000			
---	--	-----------	----	--	--	-----	------	----------	--------	--	--	--

2x
sp 09.12.15

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

114

109119


20

110704

50

111127

44

M6061T6T1.750W.065  6061T6 RDTUBE 1.750 X 0.65W		Purchased	No			160	f	44.5800	0.1579			
--	--	-----------	----	--	--	-----	---	---------	--------	--	--	--

6x
sp 10.01.07.

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

44.58

108551

2.24

109397

0.4

110885

16.69

111432

25.25

Photo →

W/O: 53308		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.01.12	160	Add to Parts list AN960JD4L B14606 (1 PER RIVET) TOTAL = 4. <u>PERMANENT CHG</u>	SAD	10-01-12 10/01/13		10.01.12	8 10/01/12

Part No: PB67-43001-59 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Picklist Print

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Page 2

Work Order ID: 53308

Parent Item: PB67-43001-59RevB1

Parent Item Name: PB67-43001-59

Comments:

Start Date: 10/30/2009

Required Date: 11/13/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MS17984-C413

Purchased

No

160

Each

12.0000

2.0000



PIN, QUICK RELEASE

8009.12.15

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

12

109031

4

111060

8

2x.

MS21042L3

Purchased

No

160

Each

3,322.000

2.0000



Nut

8009.12.15

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

3322

110844

32

111274

29

111668

761

112314

2000

112385

500

2x.

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Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Picklist Print

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Page 3

Work Order ID: 53308

Parent Item: PB67-43001-59RevB1

Parent Item Name: PB67-43001-59

Start Date: 10/30/2009

Required Date: 11/13/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-22 SCREW		Purchased	No			160	Each	126.0000	2.0000			
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>112940</div> <div>18057</div>												
<div>Loc Qty</div> <div>126</div> <div>100</div> <div>26</div>												
<div>Loc Code</div> <div></div>												
NAS1149F0332P WASHER		Purchased	No			100	Each	1,144.000	4.0000			
<div>Warehouse Location</div> <div>Main Warehouse</div> <div>ST</div> <div>18057</div>												
<div>Loc Qty</div> <div>1144</div> <div>1144</div>												
<div>Loc Code</div> <div></div>												
PB67-43001-113RevB1 Square Tube		Manufactured	No			100	Each	0.0000	1.0000			
PB67-43001-115RevC Tube End Plate		Manufactured	No			100	Each	0.0000	1.0000			
PB67-43001-117RevC Hook Plate		Manufactured	No			100	Each	0.0000	1.0000			

M18057

SAD 10-01-12

2x

SP 09.12.15

4x.

SP 10.01.07

SP 09.12.15

SP 09.12.15

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 53308

Parent Item: PB67-43001-59RevB1

Parent Item Name: PB67-43001-59





Start Date: 10/30/2009

Required Date: 11/13/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
✓ PB67-43001-119RevC 		Manufactured	No			100	Each	0.0000	1.0000			
End Cap Clevis							41478 LX				SP 09.12.15	
✓ PB67-43001-121RevB1 		Manufactured	No			160	Each	5.0000	1.0000			
Square Sleeve							43329 LX				SP 09.12.15	

Warehouse

Loc Qty

Loc Code

Location


Main Warehouse

ST

5

43329

5

✓ PB67-43001-267RevB1


Manufactured No

160

Each

9.0000

1.0000

LX

SP 09.12.15

✓ PB67-43001-267

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

9

41497

1

44976

8

LX

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Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 53308

Parent Item: PB67-43001-59RevB1

Parent Item Name: PB67-43001-59



Start Date: 10/30/2009

Required Date: 11/13/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
PB67-43001-271RevB1  Doubler		Manufactured	No			100	Each	16.0000	2.0000 			

8009.12.15

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

16

44975

16

2X

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Page 5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

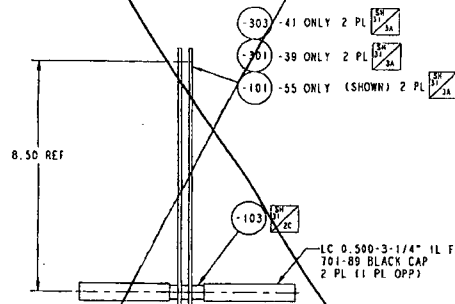
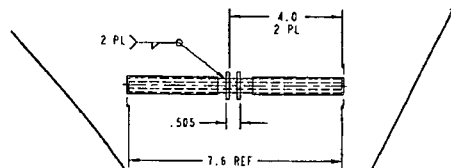
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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#53308

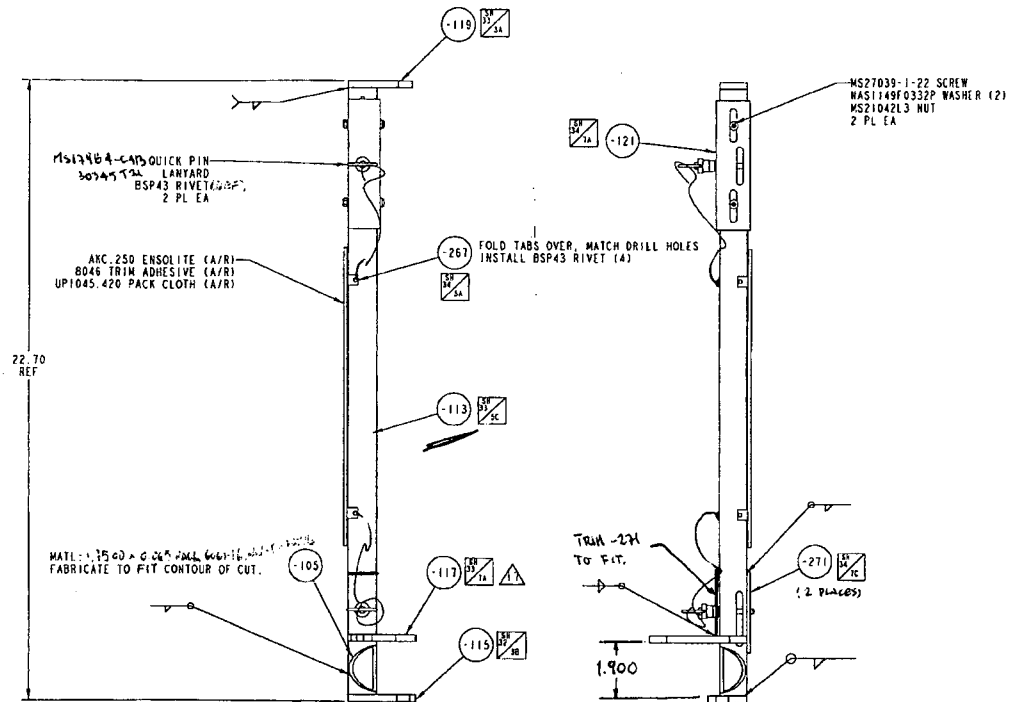
RELEASED
4-11-2



- ① -39 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ① -41 HANDLE AND LOCK-DOWN ASSEMBLY (SAME, EXCEPT AS SHOWN)
- ② -55 HANDLE AND LOCK-DOWN ASSEMBLY (SHOWN)

SCALE 0.500

SUPERCEDED BY
D3451-041-043/-045/-047



- ① -59 ADJUSTABLE ATTACHMENT ARM ASSY

SCALE 0.500

PREMIER AVIATION, INC.			
2000 Aviation Parkway, Grand Prairie, Texas 75052			
FILE NO.	DATE	REV.	BY
D105UV8	B67-43001	81	
SCALE	REV.	SHEET 14 OF 45	

ORIGINAL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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